



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D350-591-312
Job Sheet 198851



Part No: D350-591-312

Job Qty: 10 pcs

Part Name: Heli-Access-Step™ RH - High Gear, Long Step, Aerazur Float Compatible

Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 8/6/19

Job Tracking No:

Due Date: 9/10/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV B IPP Rev:A 04.03.22 New issue KJ/RF IPP Rev:B 07-06-09 Added D3572-1 JLM IPP Rev:C 08-04-02 ECN1163 DD verified by:EC IPP Rev:D 08-04-08 ECN1164 DD verified by:ec IPP Rev:D fixe route seq in bom DD 10.04.28 verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Large Fab - Steps - 1	10 pcs	9/10/19		0.00	10.00	Large Fab - 1		
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		
							Large Fab - 8		LL
							Large Fab - 9		
120	QC 9	10 pcs	9/10/19		0.00	0.00	Large Fab - 11 (Various)		
							QC 9 - 10		
							QC 9 - 18		
							QC 9 - 24		
							QC 9 - 43		DAS
							QC 9 - 50		43
							QC 9 - 9		9-89
130	QC 5	10 pcs	9/10/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		DAS
							QC 5 - 49		43
							QC 5 - 51		9-89
							QC 5 - 58		
							QC 5 - 68		



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CANADA
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Container No: S210268



Part: D350-591-312

Job No: 198851

Serial No/Batch: S210268

Revision:

Inspector:

Exp Date:

Instructions: TC STC SH92-6 Issue 1d, FAA STC SH967NE 04/12/21, BRAZIL 1

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140 Handfinish - 1-1 Chemical-B4B	10 pcs	9/10/19	0.00	1.87	QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	
					Handfinish - 1 - 1 - B4B	
					Handfinish - 1 - 2 - B4B	
					Handfinish - 1 - 3 - B4B	
					Handfinish - 1 - 4 - B4B	
					Handfinish - 1 - 5 - B4B	
					Handfinish - 1 - 6 - B4B	
					Handfinish - 1 - 7 - B4B	
					Handfinish - 1 - 8 - B4B	
					Handfinish - 1 - 9 - B4B	
					Handfinish - 1 - 10 - B4B	
					Handfinish - 1 - 11 - B4B	
					Handfinish - 1 - 12 - B4B	
					Handfinish - 1 - 13 - B4B	
					Handfinish - 1 - 14 - B4B	
					Handfinish - 1 - 15 - B4B	
					Handfinish - 1 - 16 - B4B	
					Handfinish - 1 - 17 - B4B	
					Handfinish - 1 - 18 - B4B	
					Handfinish - 1 - 19 - B4B	
					Handfinish - 1 - 20 - B4B	
					Handfinish - 1 - 21 - B4B	
					Handfinish - 1 - 22 - B4B	
150 QC 7	10 pcs	9/10/19	0.00	0.00	QC 7 - 10	
					QC 7 - 13	
					QC 7 - 14	
					QC 7 - 15	
					QC 7 - 17	
					QC 7 - 18	
					QC 7 - 19	
					QC 7 - 2	
					QC 7 - 28	
					QC 7 - 3	
					QC 7 - 30	
					QC 7 - 34	
					QC 7 - 36	
					QC 7 - 37	
					QC 7 - 41	
					QC 7 - 47	
					QC 7 - 48	
					QC 7 - 51	
					QC 7 - 58	
					QC 7 - 59	
					QC 7 - 60	
					QC 7 - 9	
					QC 7 - 68	
					QC 7 - 50	
					QC 7 - 67	
					QC 7 - 40	
					QC 7 - 24	
					QC 7 - 43	
					QC 7 - 61	
					QC 7 - 81	
180 Large Fab - Steps - 2 - B4B	10	9/10/19	0.00	10.00	Large Fab - 1 - B4B	

★ AUG 30 2019

DAS
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	pcs					Large Fab - 10 - B4B	<i>See</i>
						Large Fab - 2 - B4B	
						Large Fab - 3 - B4B	
						Large Fab - 4 - B4B	
						Large Fab - 5 - B4B	
						Large Fab - 6 - B4B	
						Large Fab - 7 - B4B	
						Large Fab - 8 - B4B	
						Large Fab - 9 - B4B	
						Large Fab - 11 - B4B (Various)	
						QC 10 - 10	
						QC 10 - 18	
						QC 10 - 24	
190 QC 10	10 pcs	9/10/19	0.00	0.00	QC 10 - 43	DAS 24	SEP 05 2019
					QC 10 - 50	9-89	
					QC 10 - 58		
					QC 10 - 9		
					QC 5 - 10		
					QC 5 - 12		
					QC 5 - 17		
200 QC 5	10 pcs	9/10/19	0.00	0.00	QC 5 - 18		SEP 05 2019
					QC 5 - 19		
					QC 5 - 22		
					QC 5 - 24		
					QC 5 - 3	DAS 24	
					QC 5 - 43	9-89	
					QC 5 - 49		
					QC 5 - 51		
					QC 5 - 58		
					QC 5 - 68		
					QC 5 - 9		
					QC 5 - 50		
					QC 5 - 30		
					QC 5 - 40		
					QC 5 - 61		
					QC 5 - 81		
210 Handfinish - 1-2- Chemical- B4B	10 pcs	9/10/19	0.00	1.87	Handfinish - 1 - 1 - B4B		★ SEP 05 2019
					Handfinish - 1 - 2 - B4B		
					Handfinish - 1 - 3 - B4B		
					Handfinish - 1 - 4 - B4B		
					Handfinish - 1 - 5 - B4B		
					Handfinish - 1 - 6 - B4B		
					Handfinish - 1 - 7 - B4B		
					Handfinish - 1 - 8 - B4B		
					Handfinish - 1 - 9 - B4B		
					Handfinish - 1 - 10 - B4B		
					Handfinish - 1 - 11 - B4B		
					Handfinish - 1 - 12 - B4B		
					Handfinish - 1 - 13 - B4B		
					Handfinish - 1 - 14 - B4B		
					Handfinish - 1 - 15 - B4B		
					Handfinish - 1 - 16 - B4B		
					Handfinish - 1 - 17 - B4B		
					Handfinish - 1 - 18 - B4B		
					Handfinish - 1 - 19 - B4B		
					Handfinish - 1 - 20 - B4B		
					Handfinish - 1 - 21 - B4B		
					Handfinish - 1 - 22 - B4B		

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220 Powdercoat - 1 White GI(A)- B4B	10 pcs	9/10/19	0.00 2.98	Powdercoat - 1 - B4B	
				Powdercoat - 2 - B4B	
				Powdercoat - 3 - B4B	8/9-9-10
				Powdercoat - 4 - B4B	
230 Handfinish - 3-1- WingWalk- B4B	10 pcs	9/10/19	0.00 1.87	Handfinish - 3 - 1 - B4B	
				Handfinish - 3 - 2 - B4B	BEB 19-09-10
				Handfinish - 3 - 3 - B4B	
				Handfinish - 3 - 4 - B4B	
				Handfinish - 3 - 5 - B4B	
240 QC 3	10 pcs	9/10/19	0.00 0.00	QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	
				QC 3 - 68	
				QC 3 - 9	
				QC 3 - 40	SEP 11 2019
				QC 3 - 19	
				QC 3 - 43	
				QC 3 - 24	
				QC 3 - 61	
				QC 3 - 81	
250 Packaging 1-1 - Pick Kit - B4B	10 ✓ pcs	9/10/19	0.00 0.00	Packaging 1 - 1 - B4B ✓	
				Packaging 1 - 2 - B4B	
				Packaging 1 - 3 - B4B	
				Packaging 1 - 4 - B4B	
				Packaging 1 - 5 - B4B	
				Packaging 1 - 6 - B4B	
				Packaging 1 - 7 - B4B	
				Packaging 1 - 8 - B4B	
				Packaging 1 - 9 - B4B	
				Packaging 1 - 10 - B4B	
				Packaging 1 - 11 - B4B	
				Packaging 1 - 12 - B4B	
				Packaging 1 - 13 - B4B	
				Packaging 1 - 14 - B4B	
				Packaging 1 - 15 - B4B	
				Packaging 1 - 16 - B4B	
				Packaging 1 - 17 - B4B	
				Packaging 1 - 18 - B4B	
				Packaging 1 - 19 - B4B	
				Packaging 1 - 20 - B4B	
				Packaging 1 - 21 - B4B	
				Packaging 1 - 22 - B4B	
				Packaging 1 - 23 - B4B	
				Packaging 1 - 24 - B4B	
				Packaging 1 - 25 - B4B	
				Packaging 1 - 26 - B4B	
				Packaging 1 - 27 - B4B	

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					Packaging 1 - 28 - B4B	
					Packaging 1 - 29 - B4B	
					Packaging 1 - 30 - B4B	
					Packaging 1 - 31 - B4B	
					Packaging 1 - 32 - B4B	
					Packaging 1 - 33 - B4B	
					Packaging 1 - 34 - B4B	
					Packaging 1 - 35 - B4B	
					Packaging 1 - 36 - B4B	
					QC 4 - 28	M.D.
260 QC 4	10 pcs	9/10/19	0.00	0.00	QC 4 - 58	
					QC 4 - 69	
					QC 4 - 9	
					QC 4 - 46	
					QC 4 - 68	
					QC 4 - 72	
					QC 4 - 74	
					QC 4 - 75	
					Packaging 3 - 1 - B4B	
270 Packaging 3-1 - Stock - B4B	10 pcs	9/10/19	0.00	0.00	Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
275 DC - 1 - B4B	10 pcs	9/10/19	0.00	0.00	DC - 1 - B4B	
					DC - 2 - B4B	SEP 16 2019
280 QC 21 - FG	10 pcs	9/10/19	0.00	0.00	QC 21 - FG - 21	
					QC 21 - FG - 70	
					QC 21 - FG - 53	

Max B.

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Part Op 110 - 1-Bevel end for welding FWD ONLY 2-Weld Support using Jig DT10115, weld Fwd End Plate as per QSI 004 & Dwg Descriptions: D3272 A/R Aluminum Rod _____ 3-Grind End Plate flush

120 - QC9- Inspect visual per QSI004- Fusion Welds

130 - QC5- Inspect part completeness to step on W/O

140 - Chemical Conversion Coat per QSI005 4.1

150 - QC7-Inspect Chemical Conversion Coat

180 - Weld per dwg A/R Aluminum rod Batch: _____ 1-Assemble Leg Assembly as per Dwg D3272. 2-Leave one rivet out until welding is complete. 3-Bevel Aft end for welding 4-Inspect for foreign object as per QSI 024 5-Weld Aft End Plate as per QSI 004 & Dwg D3272 A/R Aluminum Rod _____ 6-Grind End Plate flush 7-Install last rivet as per Dwg.

190 - QC10- Inspect visual per QSI004- ground welds

200 - QC5- Inspect part completeness to step on W/O

210 - Chemical Conversion Coat per QSI005 4.1

220 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum START TIME: 9:15. OVEN TEMPERATURE: 800°

FINISH TIME: 9:45 M193469 5146104

230 - Wing Walk as per dwg QSI005 4.4 Batch

240 - QC3- Inspect Part Finish

250 - pick kit

260 - QC4- 100% Inspect kits for completeness

270 - Identify and pack for shipping as per PPPD350-591-312 Location FG109

275 - Document Control - Photocopy bluefile and type labels as per PPP D350-591-312 CHG001

280 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D3067-1	End Plate	20 pcs (2 ea)	110-Large Fab - Steps - 1	S198236
D3219-1	Plate	20 pcs (2 ea)	110-Large Fab - Steps - 1	S199742 / 13 207455
D3272-1	Step	10 pcs (1 ea)	110-Large Fab - Steps - 1	S209302
D3065-041	Step Leg Assembly	10 pcs (1 ea)	180-Large Fab - Steps - 2 - B4B	S210056
D3066-1	Spacer	20 pcs (2 ea)	180-Large Fab - Steps - 2 - B4B	S1948137
MS20600-AD4W4	Rivet	160 Ea (16 ea)	180-Large Fab - Steps - 2 - B4B	S207585
AN3-35A	Bolt	20 Ea (2 ea) ✓	250-Packaging 1-1 - Pick Kit - B4B	S158557 ✓
AN4-13A	Bolt	80 Ea (8 ea) ✓	250-Packaging 1-1 - Pick Kit - B4B	S196190 ✓
AN5-36A	Bolt	20 Ea (2 ea) ✓	250-Packaging 1-1 - Pick Kit - B4B	S193839 ✓
D2230-3	Mounting Lug	40 pcs (4 ea) ✓	250-Packaging 1-1 - Pick Kit - B4B	S194078 ✓
D2618	Bushing	20 pcs (2 ea) ✓	250-Packaging 1-1 - Pick Kit - B4B	S192292 ✓
D2850-100-720	Abrasion Strip 4" X 7.20"	20 pcs (2 ea) ✓	250-Packaging 1-1 - Pick Kit - B4B	S212282 ✓
D3235-1	Mounting Lug	20 pcs (2 ea) ✓	250-Packaging 1-1 - Pick Kit - B4B	S187397 ✓
D3278-041	Support Assembly	10 pcs (1 ea) ✓	250-Packaging 1-1 - Pick Kit - B4B	S206077(15) S2 059241
MS21042L3	Nut	20 Ea (2 ea) ✓	250-Packaging 1-1 - Pick Kit - B4B	S204283 ✓
MS21042L4	Nut	80 Ea (8 ea) ✓	250-Packaging 1-1 - Pick Kit - B4B	S211536 ✓
MS21042L5	Nut	20 Ea (2 ea) ✓	250-Packaging 1-1 - Pick Kit - B4B	S208332 ✓
NAS1149D0363J	Washer	40 Ea (4 ea) ✓	250-Packaging 1-1 - Pick Kit - B4B	S201031 ✓
NAS1149D0463J	Washer	160 Ea (16 ea) ✓	250-Packaging 1-1 - Pick Kit - B4B	S206969 ✓
NAS1149D0563J	Washer	40 Ea (4 ea) ✓	250-Packaging 1-1 - Pick Kit - B4B	S174288 ✓

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THU 9-12-2019

Rosales, Oscar

Job Allocations				
Operation	Component Part	Required	Inventory	Alloca
110-Large Fab - Steps - 1	D3067-1	20	203	0
	D3219-1	20	95	0
	D3272-1	10	10	0
180-Large Fab - Steps - 2 - B4B	D3065-041	10	23	0
	D3066-1	20	257	0
	MS20600-AD4W4	160	1,408	0
250-Packaging 1-1 - Pick Kit - B4B	AN3-35A	20	324	0
	AN4-13A	80	1,260	0
	AN5-36A	20	219	0
	D2230-3	40	648	0
	D2618	20	208	0
	D2856-400-720	20	24	0
	D3235-1	20	287	0
	D3278-041	10	10	0
	MS21042L3	20	685	0
	MS21042L4	80	3,035	0
	MS21042L5	20	387	0
	NAS1149D0363J	40	1,694	0
	NAS1149D0463J	160	4,174	0
	NAS1149D0563J	40	2,029	0

Part Specifications

Specifications could not be found.

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WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only



Job: _____ Part No. _____		DISPOSITION Rework ☐ ☐ ☐ Scrap ☐ ☐ ☐ Use-as-is ☐ ☐ ☐		DEPARTMENT/PROCESS Skid-tube ☐ ☐ ☐ Cross tube ☐ ☐ ☐ Eng. (Non-AW) ☐ ☐ ☐ Engineering ☐ ☐ ☐ Machining ☐ ☐ ☐ Small Fab ☐ ☐ ☐ Prod. Eng. Coord. ☐ ☐ ☐ Water Jet ☐ ☐ ☐ Large Fab ☐ ☐ ☐ Finishing ☐ ☐ ☐ Rec/Store/Packaging ☐ ☐ ☐ Supplier ☐ ☐ ☐ Quality ☐ ☐ ☐						Date : _____ Sequence #: _____		QTY Affected : _____		MRB (QS1042)	
Description Work Order Deviation				Disposition											
Completed By				Lead hand / Supervisor											
								QC / QA Coordinator							
Root Cause Operator ☐ ☐ ☐ Manufacturing Process ☐ ☐ ☐ Equip/Tooling ☐ ☐ ☐ Handling/Preservation ☐ ☐ ☐ Material ☐ ☐ ☐ Product Improvement ☐ ☐ ☐ Process Improvement ☐ ☐ ☐ Human Factors ☐ ☐ ☐				FAULT CATEGORY Pressure/Forced ☐ ☐ ☐ Contamination ☐ ☐ ☐ Bending ☐ ☐ ☐ Misaligned/off center ☐ ☐ ☐ Crushing ☐ ☐ ☐ BOM/Route ☐ ☐ ☐ Cracks ☐ ☐ ☐ Broken/Damage/Defect ☐ ☐ ☐ Crimp/Kink/Ripple/Wave/Twist ☐ ☐ ☐ Incomplete/Unclear Instructions ☐ ☐ ☐ Marks/Chatter ☐ ☐ ☐ Drill Holes ☐ ☐ ☐ Mislabeled ☐ ☐ ☐ Fit/Function ☐ ☐ ☐				Other/Details:							
Positioned Wrong ☐ ☐ ☐ Outside Tolerance ☐ ☐ ☐ Drawing ☐ ☐ ☐ Finish ☐ ☐ ☐ Part Lost/Missing ☐ ☐ ☐ Misread ☐ ☐ ☐															

Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X						D350-591-213	<i>Heli-Access-Step™</i> , Short Step - High Skid, LH
	X					D350-591-214	<i>Heli-Access-Step™</i> , Short Step - High Skid, RH
		X				D350-591-215	<i>Heli-Access-Step™</i> , Short Step - Low Skid, LH
			X			D350-591-216	<i>Heli-Access-Step™</i> , Short Step - Low Skid, RH
				X		D350-591-311	<i>Heli-Access-Step™</i> , Long Step - High Skid, LH
					X	D350-591-312	<i>Heli-Access-Step™</i> , Long Step - High Skid, RH
1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
	1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
		1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
			1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
				1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
					1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
2	2	2	2	4		D2732-030	MOUNTING LUG
2	2	2	2	2		D2732-030	BUSHING
4	4	4	4			D2732-030	CUSHION
				2		D2732-030	ABRASION STRIP
2	2	2	2	2		D2732-030	MOUNTING LUG
				1		D2732-030	SUPPORT ASSEMBLY
2	2	2	2	2		AN5-26A	BOLT
				8		AN4-15A	BOLT
4	4	4	4			AN4-15A	BOLT
2	2	2	2	2		AN5-26A	BOLT
4	4	4	4	4		AN960JD10	WASHER (AN960JD10)
12	12	12	12	16		AN960JD416	WASHER (AN960JD416)
4	4	4	4	4		AN960JD516	WASHER (AN960JD516)
2	2	2	2	2		NUT	NUT
6	6	6	6	8		NUT	NUT
2	2	2	2	2		NUT	NUT
				1	1	*DSI 9410-011	STEP MODIFICATION KIT

*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 15 for Installation of the DSI 9410-011 Kit.

Change Record

Part Number: D350-591-311/-312 (EURO P/N: 704A 41 640 012/-011)

PAGE 1 OF 2

Description: HELI-ACCESS STEP, HIGH SKID, LONG STEP, LH/RH

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